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ABSTRACT:

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## (54) MAKE-UP PENCIL



(71) We, L'OREAL, a French Body Corporate of 14, rue Royale, 75008 Paris, France, do hereby declare the invention, for which we pray that a patent may be granted to us, and the method by which it is to be performed, to be particularly described in and by the following statement:—

It is known to provide certain make-up products, in particular eyelid or eyebrow make-up, in the form of pencils which allow direct application of make-up to the user's face.

For this purpose, make-up pencils have already been proposed which consist of a cylindrical stick of cosmetic material contained in a wooden surround; this type of pencil has the advantage that it can be sharpened, for instance, by a pencil sharpener so that it tapers to a point and releases the core from its wooden surround. However, as is known, solvents and fatty particles and/or waxes enter into the composition of the core with the result it has a tendency to harden during use, since the solvents evaporate and some at least of the fatty particles and/or waxes are absorbed by the wood of the surround. Moreover, for ease of application, the core of a make-up pencil is conveniently given a large diameter which therefore presupposes that the wood surround of the pencil has an even greater external diameter. In fact, most frequently, the pencil is made by assembling two hollow hemicylindrical sector elements edge to edge round a stick of the make-up product and then gluing the two assembled elements to constitute the wooden surround. It is therefore indispensable to provide a wooden surround of sufficient thickness to ensure a good bond between the two sector elements from which it is built and since, moreover, the core is large in diameter leaving the resulting make-up pencil bulky and therefore too cumbersome and difficult to handle.

The objects of the present invention is to remedy the above mentioned two drawbacks.

According to the present invention there is

provided a process for manufacturing a make-up pencil constituted by a shell of a plastic material around a core of a cosmetic product and a leakproof cap positioned on one end of the shell, the plastic material from which the said shell is made being capable of being cut when the pencil is being sharpened; such process comprising bringing the cosmetic product to its liquid state at a temperature below the deterioration temperature of the shell, and pouring the liquid cosmetic product into the inside of the shell through the other end of the shell which is not sealed by the cap.

The invention also provides a make-up pencil manufactured by the above process and comprising an elongate tubular plastic sheath, a closure cap at one end defining a conical end to the interior of the shell, a stopper closing the other end of the shell, and the cosmetic product enclosed within the shell.

The surround of the make-up pencil is thus made in a single piece without the need to assemble two elements by bonding; it can be of small thickness i.e. the make-up pencil may, in spite of the thickness of the core, be smaller in bulk than the pencil of a conventional design comprising a wooden surround. To this, there is added the advantage that the core of the pencil of the invention substantially retains the same hardness in the course of use since neither are the fatty constituents of the core absorbed by the non-porous and impermeable wall of the plastics shell nor can the solvents which may possibly be contained in it evaporate.

In a preferred form, the cap of the pencil defines a conical cavity at the end of the shell which has the shape and dimensions of the tip of the pencil that is to be made; the cap is made of plastic. On solidification of the poured cosmetic substance, the end of the shell which has no cap can be sealed, for instance, by means of a small stopper.

It should be observed that if the cosmetic product is moulded within its shell as pro-

posed above in the preparation of the make-up stick according to the invention, one production stage is avoided i.e. the one which consists in locating a premoulded core stick within an external plastic shell. Moreover, in the processes according to the invention, the tip of the core is preformed by locating the cap on one of the ends of the shell before the cosmetic product is poured in its liquid state.

In a preferred embodiment, the core is of a general cylindrical shape and comprises a tip which essentially takes the shape of a truncated cone projecting from said one of the shell; at the end of the shell where the tip of the core projects, the leak tight closing cap is positioned.

As with pencils of the usual kind, the make-up pencil is also capable of being sharpened when the point is blunt by providing a plastic substance for the shell which can be subjected to cutting as, for instance, an impact polystyrene or a polyethylene.

Accordingly the invention also provides a pencil sharpener for the above make-up pencil, such pencil sharpener comprising a conical cavity fitted with a cutting blade for sharpening said one end of the pencil when introduced therein, the inlet of the conical cavity being extended by a cylindrical bore which is coaxial with said cavity and intended to surround the make-up pencil over at least part of its length during sharpening.

Since the core of the make-up pencil is fragile by reason of its pasty consistency and since the thickness of the plastic shell is relatively small as compared with a conventional pencil with a wood surround, it has been found that sharpening a pencil according to the invention by means of a conventional pencil sharpener is a particularly delicate operation. To overcome this drawback and to make it possible to sharpen a make-up pencil of the type described above without any difficulty and without the risk of breaking the end of the core, the pencil sharpener proposed in accordance with the invention has the particular feature that it comprises in the extension of the conical cavity a cylindrical bore which serves to guide the make-up pencil coaxially into said cavity.

In order that the present invention may more readily be understood, the following description is given of one embodiment illustrated with reference to the accompanying drawings, in which:—

Figure 1 shows a longitudinal cross-section of a finished pencil according to the invention;

Figure 2 shows schematically in perspective, the elements of the make-up pencil according to the invention in the course of

casting the make-up product *in situ* within a previously moulded shell closed at one of its ends by a leak proof cap; and

Figure 3 is a cross-section of a pencil sharpener used for sharpening the make-up pencil of Figure 1.

Reference to the drawings will show that the make-up pencil 1 consists of a cylindrical shell enclosing a stick 3 of the cosmetic product which can be used for making up eyelids or eyebrows.

The cylindrical shell 2 is an impermeable, non-porous shell which is open at its two ends; it is made of a plastic material such as, for instance, polyethylene or an impact polystyrene. In this example of embodiment the shell 2 has a length of 50 to 100 mm, an internal diameter of 2 to 15 mm and a wall thickness of 0.8 to 3 mm.

The core stick 3 of the cosmetic product within the plastic shell 2 is also substantially cylindrical and constitutes the core of pencil 1. Stick 3 takes the form of a pasty consistency and its composition is one of those usually used for make-up pencil cores.

The end of the stick 3 of the cosmetic product projecting from the shell 2 terminates at a conical end which constitutes the tip 4 of the pencil. During storage, the tip 4 is covered in a leak proof manner by a cap 5 surrounding the corresponding end zone of shell 2. The inside of cap 5 comprises a conical cavity having the shape and dimensions of the tip 4 which it is intended to contain. The other opening of the shell 2, which is not fitted with cap 5, is sealed by a stopper 6.

The make-up pencil described above has the advantage of comprising a plastic shell whose thickness is relatively small in relation to the diameter of core 3 which it contains. Moreover, fatty particles included in the composition of core 3 are not susceptible to being absorbed by the wall of shell 2 and the solvents are not subject to evaporation since core 3 is enclosed along its whole length at each end during storage within a leak proof and non-porous shell 2, cap 5 and sealing stopper 6. It follows that core 3 maintains during use, and until it is completely used up, practically the same degree of hardness in distinction to the conventional type of make-up pencils which have a wood surround.

In the manufacturing process shown in Figure 2, the core 3 is cast directly *in situ* within the plastic shell 2 while the bottom of the shell 2 is closed by cap 5 and the top is open to allow the introduction of the cosmetic product by means of the suitable distributor 7.

The cosmetic product which is brought to a liquid state by heating, is poured into shell 2 until it has been completely filled,

although nevertheless leaving an empty space above the cast product to allow the upper end of shell 2 to be sealed by the insertion of a sealing stopper 6. Because of its form the cap 5 allows the preforming of the tip 4 of the core 3 without necessitating initial sharpening of the core. When core 3 has been cast *in situ* within shell 2, and has solidified there, and when the end of the said shell has been sealed by stopper 6, the make-up pencil may be stored or transported for marketing without the need for any additional impermeable packing, since the core 3 is enclosed in a leak proof assembly constituted by the shell 2, cap 5 and stopper 6.

Like all conventional make-up pencils, the make-up pencil 1 may be sharpened by means of a pencil sharpener to sharpen the tip 4 when blunted. The plastic of which shell 2 is made, renders this sharpening operation feasible. Nevertheless, core 3 of the make-up pencil is, because of its composition, fragile and moreover, it has a large diameter while the wall of the surrounding shell 2 is of a small thickness. Because of this, the sharpening of make-up pencil 1 with a conventional pencil sharpener is particularly tricky.

Figure 3 shows a pencil sharpener 8 which has been specially designed to be used for sharpening make-up pencil 1. The pencil sharpener 8 comprises a conical cavity 9, in the usual way, within which the sharpening of core 3 is effected by a cutting blade 10. The essential special feature of pencil sharpener 8 derives from the fact that it comprises in the extension of the inlet of conical cavity 9, a cylindrical bore 11 intended to contain the shell 2 over part of its length while pencil 1 is being sharpened. This bore 11 serves to guide the end of the make up pencil within the conical cavity 9 where the sharpening is effected. After the end of the pencil has been pushed to the bottom of pencil sharpener 8, the pencil 1 is turned in relation to the pencil sharpener in order to sharpen tip 4 contained in cavity 9. This tip 4 is not susceptible to damage, in spite of its fragility, because of the guidance coaxially within the conical cavity obtained by cylindrical bore 11.

#### WHAT WE CLAIM IS:—

1. A process for manufacturing a make-up pencil constituted by a shell of a plastic material around a core of a cosmetic product and a leakproof cap positioned on one end of the shell, the plastic material from which the said shell is made being capable of being cut when the pencil is being sharpened; such process comprising

bringing the cosmetic product to its liquid state at a temperature below the deterioration temperature of the shell, and pouring the liquid cosmetic product into the inside of the shell through the other end of the shell which is not sealed by the cap.

2. A process according to claim 1, wherein the cap defines at said one end of the shell a conical cavity having the shape and dimensions of the tip of the pencil which is intended to be made.

3. A process according to claim 1, wherein after solidification of the poured cosmetic product, said other end of the shell is sealed.

4. A process for manufacturing a make-up pencil substantially as hereinbefore described with reference to the accompanying drawings.

5. A make up pencil obtained by the process of any one of the claims 1 to 4.

6. A make-up pencil according to claim 5, and comprising an elongate tubular plastic sheath, a closure cap at one end defining a conical end to the interior of the shell, a stopper closing the other end of the shell, and the cosmetic product enclosed within the shell.

7. A pencil according to claim 6, wherein the wall of the plastic shell has a small thickness in relation to the cross section of the core.

8. A pencil according to claim 6 or 7, wherein the wall of the shell is non-porous and impermeable to solvents contained in the cosmetic product.

9. A pencil according to claim 7, wherein the plastic from which the shell is made is an impact polystyrene and/or a polyethylene.

10. A pencil according to any one of claims 6 to 9, wherein the core is of cylindrical shape and comprises a tip of substantially truncated conical shape projecting from the shell.

11. A pencil according to claim 10, wherein a said closing cap is positioned in a leak proof manner on the said one end of the shell where the tip of the shell projects.

12. A make up pencil substantially as hereinbefore described with reference to, and as illustrated in, the accompanying drawings.

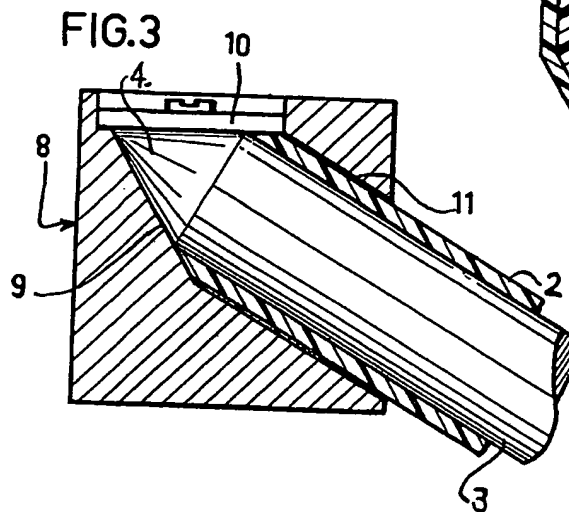
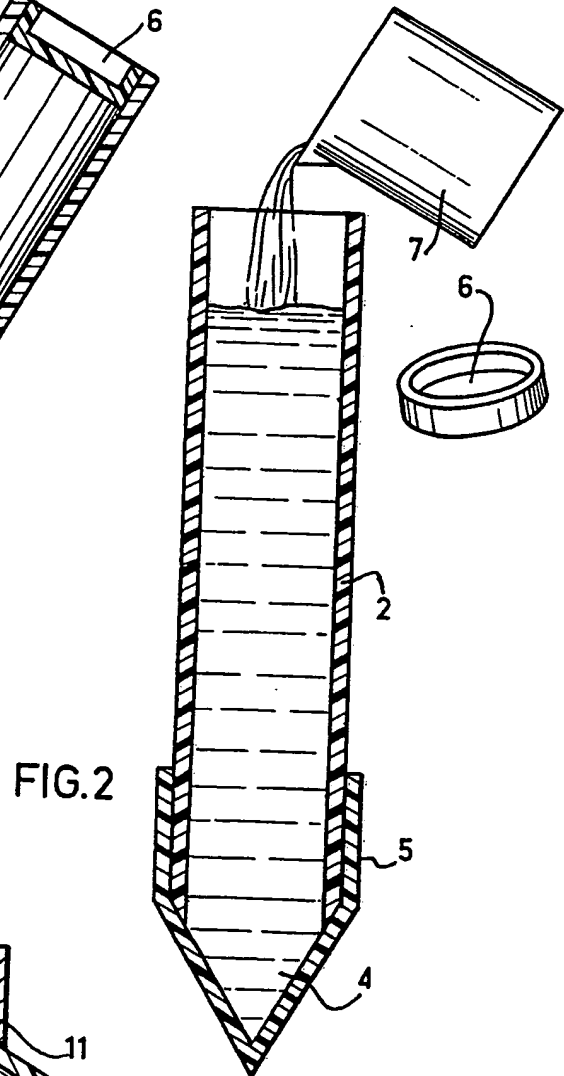
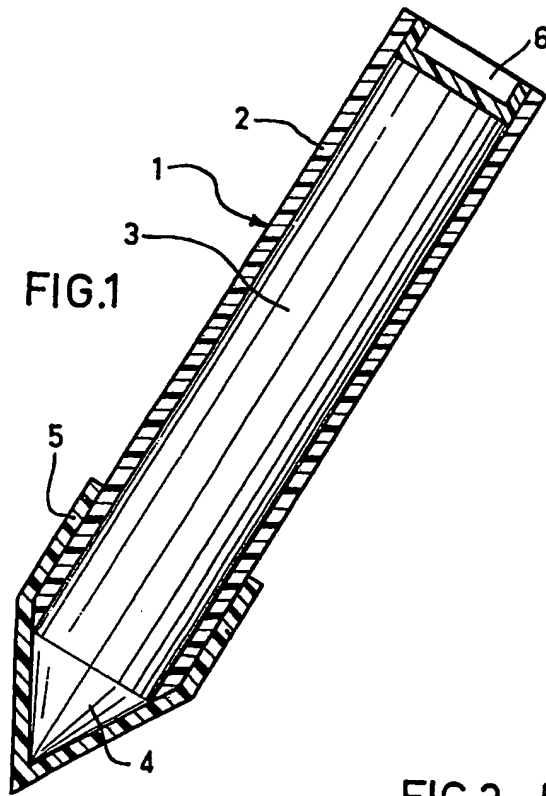
13. A pencil sharpener when used for sharpening a make-up pencil according to any one of claims 5 to 12, such pencil sharpener comprising a conical cavity fitted with a cutting blade for sharpening said one end of the pencil when introduced therein, the inlet of the conical cavity being extended by a cylindrical bore which is coaxial with said cavity and intended to sur-

round the make-up pencil over at least part of its length during sharpening.

- 5 14. A pencil sharpener according to claim 13, and substantially as hereinbefore described with reference to and as illustrated in Figure 3 of the accompanying drawings.

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